

Work Order ID 86441

June-28-12 1:04:43 PM

86441

Page 1

Item ID: D2855

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Cap

Stop ***NS2***

Start Date: 28/06/2012 Start Qty: 60.00

60

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2855

Rev B

100

0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 17343 Cast per Dwg D2855 Material Release Note Required

CX 12/06/29 60

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

600X

SP 12-7-18

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

8/12/07/20
DAS
16
S-23

cut
60
2547

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Setup Start

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Item Name: Cap

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60

Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Drill as per Dwg D2855 using DT82352- Open holes to 19/64"3- Deburr

60

60

0

0

Ac
12.07.30
FF 12.08.07

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Smb
12.8.07

DAS
16
2.83 12/08/07

60
cane

150

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

8-10

3200F

8-40

60 X 4

Mif
12/08/13

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NS2

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Cust Item ID:

Required Date: 12/07/2012 Req'd Qty: 60.00

60

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							
170 *170* Small Fab Small Fab Small Fab	Small Fab Memo Install Inserts as per Dwg D2855	0.00 0.00							
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

DAS
16
8-23 12/06/15

x60 4 M 12/08/15

DAS
16
8-23 12/08/15

(cont)
x60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 12/07/2012 Req'd Qty: 60.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: FP-2

0.00

190

Packaging

Memo

0.00

Packaging

X60 ✓ all also 15

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLJ 12/08/16

MLJ 12/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-28-12 1:04:47 PM

Page 1

Work Order ID: 86441

86441

Parent Item: D2855

D2855

Parent Item Name: Cap

Start Date: 28/06/2012

Required Date: 12/07/2012

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP: B00.06.22 Added receiving step & removed P/O for powder coat EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	1,071.000	2	120			
AI S7-1032-225									**	ML 12/08/15			
INSERT													

Location

Loc Qty

Loc Code

ST282

1071

100896

135

111529

27

118520

909

11122290

X120

D2855P

Purchased

No

170

Each

100.0000

1

60

D2855P

**

ML 12/08/16

Cap

Location

Loc Qty

Loc Code

ST

86441

(60)

100

84952

100

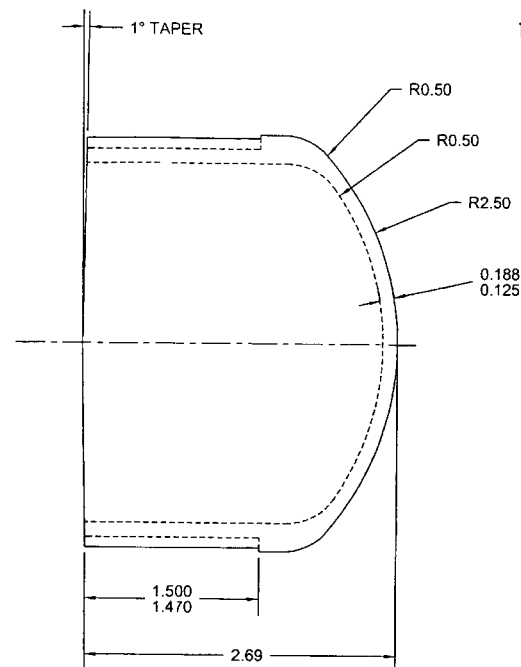
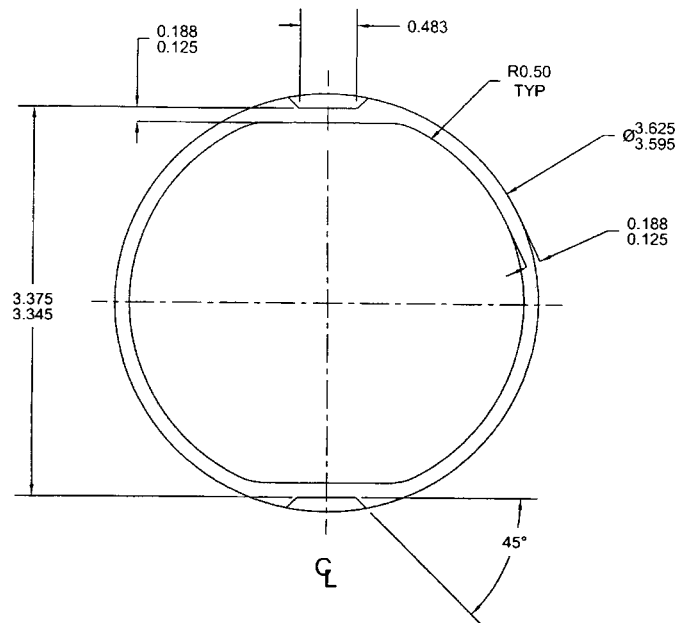
W/O:		WORK ORDER CHANGES					
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86491 MLJ
12/00/28

D2855C CASTING DETAIL B

RELEASED
09/12/15 MLJ

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<u>RF</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>RF</u>	D2855	SHEET 1 OF 3
APPROVED	<u>RF</u>	TITLE	SCALE
DE APPR.	<u>RF</u>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

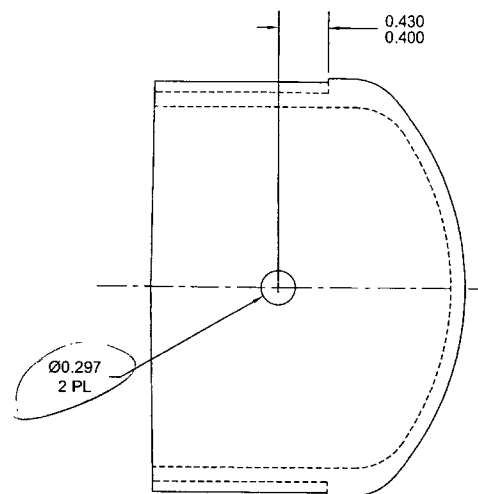
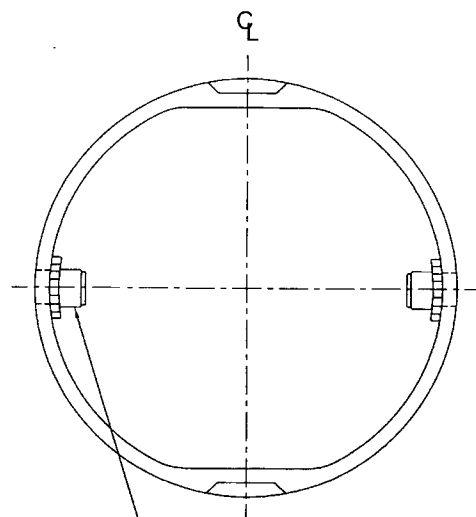
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

26441



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

RELEASED
[Signature]

NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D2855	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CAP	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

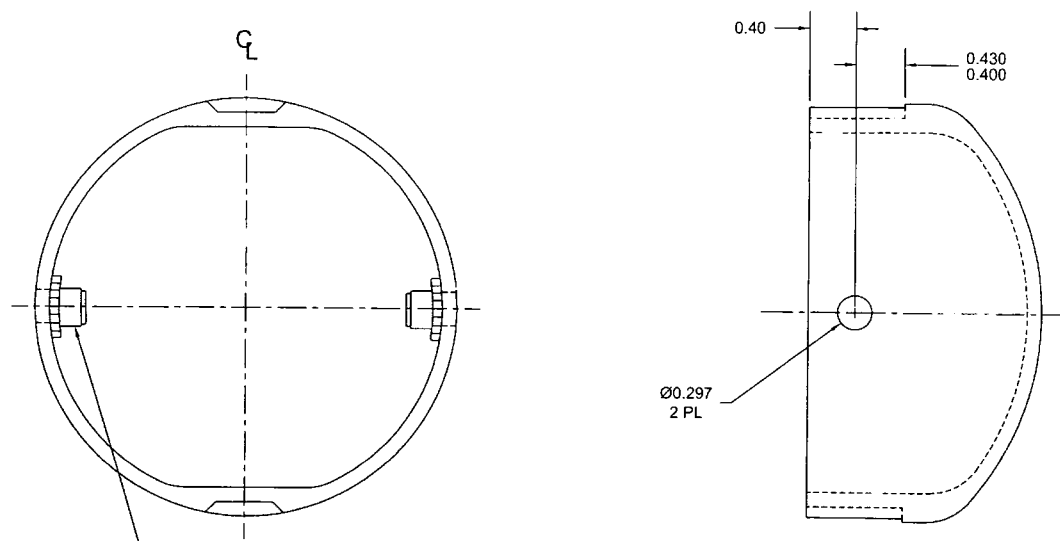
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

26441







INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

RELEASED
24/11/2010

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2855	REV. B
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		CAP	SCALE
DE APPR			NTS
DATE	09.06.30	<small>COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO17343

Purchase Order Date 6/29/12

PO Print Date 6/29/12

Page Number 1 of 1

Order From :

VC-ALU001

ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	514 683 9777	Requisition Nbr	
Vendor Fax	514 683 0375	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P	Cap	7/13/12 Yes	60.00 Each	FedEx PI collect	\$18,7000	\$1,122.00

Special Inst: AS PER DWG D2855 REV. B
B86441
MATERIAL: A356.2(F)

PO Total: \$1,122.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 6/29/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required - YES NO

**7 CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE**

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

2225 CHEMIN ST. FRANCOIS, DORVAL, QC H9P-1K3
TEL : (514) 683-9777 FAX: (514) 683-0375

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W. Série no. / Serial no.

1270 Aberdeen Street

Packing
Date: **16/07/2012** Slip No. **34093, 34094**

Hawksbury, ON, K6A 1K7

Votre No. Commande **17343, 17404**
Your order No.

Ceci est pour certifier que le matériel liste ci-dessous est selon les spécifications du bon d'achat ci-haut, et que les documents en évidence des rapports et certificats de détaillants sont en filière dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantité Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release nos
60	D 2855 CAP	Z098046 16 2-03 17/07/12	A356.2	B# 1219401
50	D 2855 CAP	Z098046	A356.2	B# 1219401

**Analyse
Analysis (as in Ingot C - 625 1819)**

(Si)	7.1%	(Al)	balance
(Fe)	0.10%		
(Cu)	<0.01%		
(Mn)	<0.01%		
(Mg)	0.35%		
(Zn)	<0.01%		
(Ti)	0.12%		

Donnée
Yield :

Résistance à la tension :
Tensile Strength :

Allongement par pouce carré :
P.S.I. Elongation :

Pour et au nom de
For and on behalf of :

**FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD**

Dept/Dep :
Par/Per :

Coc-100

849180120935

DELIVERY RECORD /
ETIQUETTE DE LIVRAISON

849180120935

DELIVERY RECORD /
ETIQUETTE D'AVIS DE RECEPTION

849180120935

ETIQUETTE

849180120935

Not all services and options available to all destinations. / Certains services et options ne sont pas disponibles pour toutes les destinations.

Origin Station ID N.I. de la succ. d'origine	Dest. Station ID N.I. de la succ. dest.	Hold Station ID N.I. de la succ. dét.
Received At / Recp A 1 <input type="checkbox"/> Reg. Stop Arrêt régulier	2 <input type="checkbox"/> On-Deli Stop Arrêt sur demande	3 <input type="checkbox"/> Drop box Boîte à colis
4 <input type="checkbox"/> BSC / Comp- toir de dépôt		5 <input type="checkbox"/> Station Succursale
Freight Fret	G.S.T. / H.S.T. T.P.S. / T.V.H.	P.S.T. / Q.S.T. T.V.P. / T.V.Q.
Other Autre		Total

1 From / Expéditeur

Date

Sender's Name
Nom de l'expéditeurPhone
TéléphoneCompany
Nom de la sociétéAddress
Adresse

Dept./Floor/Service/Étage

Address
AdresseCity
Ville

Province

Postal Code
Code postal2 Your Internal Reference
Votre référence interne

3 To / Destinataire

Recipient's Name
Nom du destinatairePhone
TéléphoneCompany
Nom de la sociétéAddress
Adresse

We cannot deliver to P.O. boxes. / Nous ne livrons pas aux cases postales.

Address
AdresseCity
Ville

Province

Postal Code
Code postal

4 Shipment Information / Informations sur l'envi

Total Packages
Nombre total
de colisTotal Weight
Poids total☐ lb.DIM
Poids
VOL☐ in.
poTotal Declared Value
Valeur totale déclarée

\$

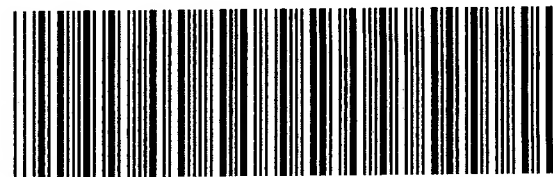
5a Express Package Service / Service colis express

1 ☐ FedEx Priority Overnight6 ☐ FedEx First Overnight3 ☐ FedEx 2DayHigher rates apply.
Des tarifs plus élevés s'appliquent.

5b Express Freight Service / Service fret express

7 ☐ FedEx 1Day Freight

Reserv. / Numéro de réservation

FedEx
ExpressIntra-Canada Air Waybill
Lettre de transport aérien intérieurePrepaid Cash Copy
Copie d'envoi prépayé

7 Special Handling / Manutention spéciale

1 ☐ HOLD at FedEx Location / RETENIR à la succursale FedEx

May not be in the same city. Not available for FedEx First Overnight. / Peut être située dans une autre ville. Pas disponible pour FedEx First Overnight.

3 ☐ SATURDAY Delivery / Livraison le SAMEDI

Available to select locations. Not available for FedEx First Overnight and FedEx 1Day Freight. / Disponible à certains endroits. Pas disponible pour FedEx First Overnight et FedEx 1Day Freight.

Does this shipment contain dangerous goods? / Cet envoi contient-il des marchandises dangereuses?*

Must check one box / Cocher une seule case

No ☐ NonYes ☐ Oui

As per attached Shipper's Declaration / Selon la déclaration de l'expéditeur, ci-jointe

8 ☐ Yes ☐ Oui

Shipper's Declaration not required / Déclaration de l'expéditeur non requise

6 ☐ Dry Ice / Dioxyde de carbone, solide

9, UN 1845

x

kg

*Dangerous goods (including Dry Ice) cannot be shipped in FedEx packaging. / Les marchandises dangereuses (y compris le dioxyde de carbone solide) ne peuvent pas être expédiées dans des emballages FedEx.

CA ☐ Cargo Aircraft Only
Avion cargo uniquement

8 Payment Bill transportation charges to / Paiement facturer le transport à:

1 ☐ Sender / Expéditeur

Acct No. in Section 1 will be billed. / Les frais seront imputés au numéro de compte figurant à la rubrique 1.

Enter FedEx Acct. No. or Credit Card No. below.
Indiquer ci-dessous le n° de compte FedEx ou de la carte de crédit.2 ☒ Recipient
Destinataire3 ☐ Third Party
Tierce partie4 ☐ Credit Card
Carte de crédit5 ☐ Cash / Cheque
Argent liquide / ChèqueCredit Card Exp. Date
Date d'expiration de la carte de créditCredit Card Auth.
Autorisation de carte de crédit

9 Sign to Authorize Delivery Without a Signature / Signer pour autoriser la livraison sans signature

Sender authorizes Federal Express to deliver this shipment without obtaining a delivery signature and shall indemnify and hold harmless Federal Express from any claims resulting therefrom. / L'expéditeur autorise Federal Express à livrer le présent colis sans avoir obtenu de signature attestant de la livraison et libère Federal Express de toute réclamation pouvant en résulter.

Sender's Signature
Signature de l'expéditeur

10 Required Signature / Signature requise

Sender's signature & liability limitation / Signature de l'expéditeur et limite de responsabilité. Use of this Air Waybill constitutes your agreement to all the terms and conditions on the back of this Air Waybill and in our current Service Guide, which may limit our liability for damage, loss, delay, shortage, misdelivery, misinformation, or failure to provide information in connection with your shipment. Features of service may vary from location to location. See our current Service Guide or call 1.800.GoFedEx 1.800.463.3339 for further information.

En utilisant cette lettre de transport aérien, vous acceptez les clauses et conditions qui figurent au verso de celle-ci ainsi que dans notre Guide des services courant, clauses qui peuvent limiter notre responsabilité à l'égard des dommages, pertes, retards, livraisons incomplètes, livraisons erronées, informations fautives ou incapacité de fournir de l'information sur votre envoi. Les modalités de service peuvent varier d'un endroit à l'autre. Voir notre Guide des services courant ou téléphoner au 1.800.GoFedEx 1.800.463.3339 pour plus d'information.

Sender's Signature
Signature de l'expéditeurPART 157259
Rev. Date 5/04
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